

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: dat Date: 19/05/05QA Closed: RMA Date: 15/04/13

Work Order: <u>92092</u> Part No. <u>0067-43001-67</u> NCR No. <u>15-4809</u>				DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐																								
Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐																								
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																								
Large Fab ☐	Composite ☐	Supplier ☐																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data ☐	14/01/13	139	1	1 part scrap Tooling is not adequate to make the part Found a another way to make part more accurate & easier 3 set-up	DAS 16 9-89 032042 15/04/13	Scrap & destroy No replace \$132 ⁰³	SB 14/01/13	DAS 27 9-89 14/1/09	DAS 17 9-89 14/1/09																		
Equip/Tooling ☒																											
Operator ☐																											
Material ☐																											
Setup ☐																											
Other ☐																											
Process ☐																											
Supplier ☐																											
Training ☐																											
Unapproved ☐																											

RE Used Better tooling

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☒ Outside Dimensions
---	---	--

☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☒ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
---	---

Work Order ID 92092

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92092

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Item ID: PB67-43001-67 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: PB67-43001-67
 Start Date: 10/23/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 11/2/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>H130137</u> Large Fab Memo 1- Install nut plates as per dwg 2- Weld assembly as per dwg B67-43001	0.00 0.00							14/23/11 DAS 36 9-89
160 *160* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							2x DAS 43 9-89 APR 08 2015
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							2 APR 08 2015 DAS 24 9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY									
Landing Gear			General						
☐	Bending	☐	Bend	☐	Grain	☐	Ovalized	☐	Pressure/Forced
☐	Centre Not Concentric to O/S	☐	BOM/Route	☐	Hardware	☐	Over/Under tolerance	☐	Temperature/Cure
☐	Cracks	☐	Broken/Damaged	☐	Inspection Incomplete	☐	Part Incorrect	☐	Weld
☐	Crushed/Crimped	☐	Burrs	☐	Instructions Incomplete/Unclear	☐	Part Lost/Missing	☐	Wrong Stock Pulled
☐	Cuffs	☐	Contamination	☐	Maintenance	☐	Part Moved	☐	Other
☐	Heat Treat	☐	Countersink	☐	Mislabeled	☐	Positioned Wrong		
☐	Inspection Strip in Tube	☐	Cut Too Short	☐	Misread	☐	Power Loss/Surge		
☐	Ripples in Bend	☐	Drill Holes	☐	Offset				
☐	Torque Waves in Extrusion	☐	Drawing	☐	Out of Calibration				
☐	Turning Sequence	☐	Finish	☐	Out of Sequence				
☐	Wave/Twist in Tube	☐	Folio	☐	Outside Dimensions				

Work Order ID 92092

92092

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Item ID: PB67-43001-67

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: PB67-43001-67

Stop *NS2*

Start Date: 10/23/2012 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: WAS	0.00							
200									
Packaging	Memo	0.00				2			DAS 24 9-89
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MLJ 15 04-10

ME
15-7-8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data ☐												
Equip/Tooling ☐												
Operator ☐												
Material ☐												
Setup ☐												
Other ☐												
Process ☐												
Supplier ☐												
Training ☐												
Unapproved ☐												
FAULT CATEGORY												
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	

Picklist Print

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Work Order ID: 92092

Parent Item: PB67-43001-67

Parent Item Name: PB67-43001-67

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-06-19 new issue DD verified by:ec
IPP Rev:B 08-09-23 remove alodine and QC3 DD verified EC IPP rev B 10.09.30 per rev C
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L3 Nutplate		Purchased	No				Each	315.0000		60		14/03/11	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST303		1							
				120910		1							
				ST318		289							
				123346		289							
				ST321		25							
				121825		25							
PB67-43001-149 Side Plate		Manufactured	No				Each	6.0000		20		14/03/11	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		6							
				41560		6							
MS20426AD3-4 RIVET		Purchased	No			100	Each	20,166.000	12	120		14/03/11	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				333		1641							
				122452		1641							
				FG		8000							
				123352		8000							
				ST316		135							
				104374		135							
				ST334		10390							
				123021		2390							
				123164		8000							

M128429 60x

B99999
B114062

M127432
120x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											

FAULT CATEGORY									
Landing Gear			General						
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced					
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure					
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld					
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled					
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	☐ Positioned Wrong					
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Power Loss/Surge	☐ Other					
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread							
☐ Ripples in Bend	☐ Drill Holes	☐ Offset							
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration							
☐ Turning Sequence	☐ Finish	☐ Out of Sequence							
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions							

Picklist Print

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Work Order ID: 92092

Parent Item: PB67-43001-67

Parent Item Name: PB67-43001-67

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 10.00

Required Qty: 10.00

M6061T6S.090

Purchased

No

150 sf

169.5850

0.5944

6.2568421

1312-10-

6061-T6 .090 Sheet

Location

Loc Qty

Loc Code

MAT021

169.585

111382

73.585

123279

96

⑩

123279

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

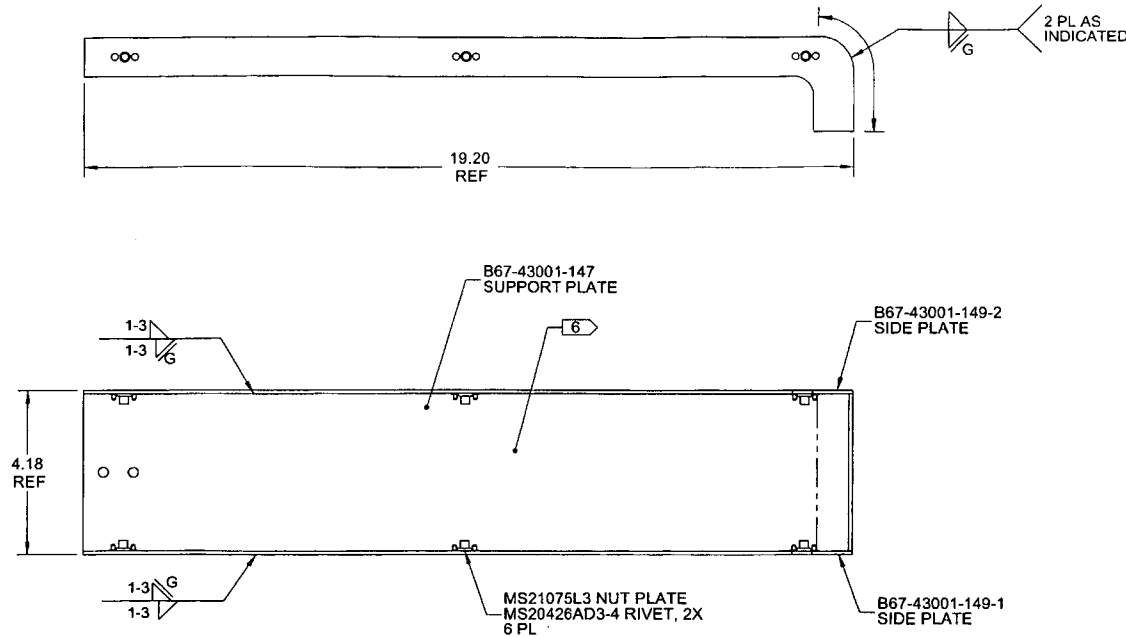
DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											

FAULT CATEGORY									
Landing Gear			General						
☐	Bending	☐	Bend	☐	Grain	☐	Ovalized	☐	Pressure/Forced
☐	Centre Not Concentric to O/S	☐	BOM/Route	☐	Hardware	☐	Over/Under tolerance	☐	Temperature/Cure
☐	Cracks	☐	Broken/Damaged	☐	Inspection Incomplete	☐	Part Incorrect	☐	Weld
☐	Crushed/Crimped	☐	Burrs	☐	Instructions Incomplete/Unclear	☐	Part Lost/Missing	☐	Wrong Stock Pulled
☐	Cuffs	☐	Contamination	☐	Maintenance	☐	Part Moved	☐	Other
☐	Heat Treat	☐	Countersink	☐	Mislabeled	☐	Positioned Wrong		
☐	Inspection Strip in Tube	☐	Cut Too Short	☐	Misread	☐	Power Loss/Surge		
☐	Ripples in Bend	☐	Drill Holes	☐	Offset				
☐	Torque Waves in Extrusion	☐	Drawing	☐	Out of Calibration				
☐	Turning Sequence	☐	Finish	☐	Out of Sequence				
☐	Wave/Twist in Tube	☐	Folio	☐	Outside Dimensions				

ITEM	QTY -67	P/N	DESCRIPTION
1	X	B67-43001-67	90-DEGREE SUPPORT PLATE ASSY
2	1	B67-43001-147	SUPPORT PLATE
3	1	B67-43001-149-1	SIDE PLATE
4	1	B67-43001-149-2	SIDE PLATE
5	12	MS20426AD3-4	RIVET
6	6	MS21075L3	NUT PLATE



B67-43001-67 90-DEGREE BLADE SUPPORT ASSY

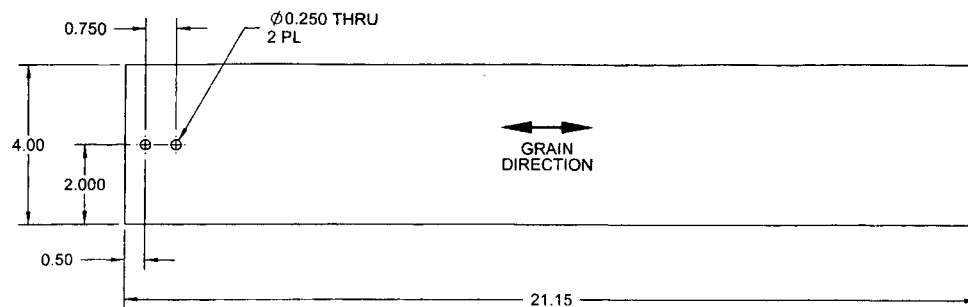
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-67" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs
- 8) WELDING: PER QSI 004

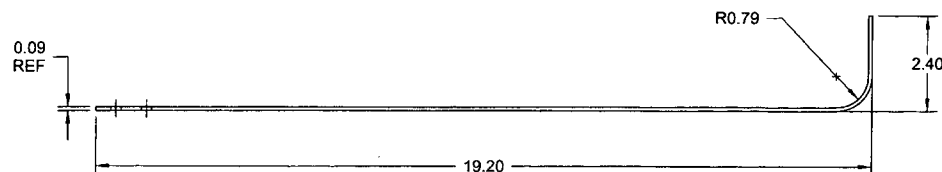
UNCHECKED
SUBMITTED
WITH
92092 MJS
12-10-25

RELEASED
2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 9 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-67 TITLE 90-DEGREE BLADE SUPPORT ASSY COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. C	
DRAWN			SHEET 1 OF 1	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED	MP			
DE APPR.	N/A			
DATE	10.04.28			



B67-43001-147F SUPPORT PLATE FLAT PATTERN



B67-43001-147 SUPPORT PLATE
(MAKE FROM B67-43001-147F)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.090
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.74 lbs

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 24 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.03
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	MD	B67-43001-147	SHEET 1 OF 1	
APPROVED	MD	TITLE	SCALE	
DE APPR.	N/A	SUPPORT PLATE	NTS	
DATE	09.03.03		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

